

# ES 316L-16

Type Acid-rutile

SMAW

E316L-16

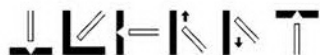
**ESWECO**  
*The Art of Welding*

## Description

ES 316L-16 is a stainless electrode of the 19Cr12Ni2.8Mo type, designed for the vertical-down welding of steels of similar composition. ES 316L-16 produces beads with a very good finish and a smooth transition to the joint edges. The slag volume is fairly small and is easy to manipulate and easy to remove.

### Current

DC+, AC OCV 60 V



## Classifications

EN 1600	E 19 12 3 LR 1 1
SFA/AWS A5.4	E316L-16
Werkstoff Nr.	1.4430

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.7	0.9	18.0	12.0	2.8	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	440
Tensile strength, MPa	600
Elongation A4, %	40

### Charpy V

Test temps, °C	Impact values, J
+20	65
-120	38

Ferrite content FN 3-10

## Approvals

ABS E316L-16

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	60-90	30
3.2	350	80-125	31
4.0	350	120-170	32